



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

split

10

DAS
21
9-60

D3319-3
Job Sheet 204609

Part No: D3319-3

Job Qty: *12* pcs

Part Name: Full Length Wearplate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/13/19

Job Tracking No:

Due Date: *1/17/20* *Jan 28*

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IPP: A 05.05.12 New issue KJ/JLM IPP Rev:B Now on Waterjet 06-10-03 JLM IPP REV:C 17.10.25 AS PER
DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		1/17/20	0.17	2.80	Waterjet - Flow		<i>20/02/10</i>
110	QC 2	12 pcs		1/17/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		<i>20/02/10</i>
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120	QC 8	12 pcs	1/17/20	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
140	Small Fab - Brake NC - B4B	12 pcs	1/17/20	0.25 0.80	Small Fab - Brake - 1 - B4B	DAS 30 FEB 12 2020
					Small Fab - Brake - 2 - B4B	9-89
					Small Fab - Brake - 3 - B4B	
150	QC 5	12 pcs	1/17/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	DAS
					QC 5 - 24	24
					QC 5 - 3	9-89
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
160	Automated Welding - B4B	12 pcs	1/17/20	0.00 3.82	Automated Welding - 1 - B4B	N/V Feb 10/20
170	QC 10	12	1/17/20	0.00 0.00	QC 10 - 10	

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	pcs			QC 10 - 18	68-6 DAS 24 9-89	DAS 24 9-89
				QC 10 - 24		
				QC 10 - 43		
				QC 10 - 50		
				QC 10 - 58		
				QC 10 - 9		
				QC 10 - 68		
180 QC 5	12 pcs	1/17/20	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22	DAS 24 9-89	
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
				QC 5 - 61		
				QC 5 - 81		
190 Spray Paint - 2 - B4B	12 pcs	1/17/20	0.00 1.20	Spray Paint - 1 - B4B		
				Spray Paint - 2 - B4B		RD 20-2-21
				Spray Paint - 3 - B4B		
				Spray Paint - 4 - B4B		
200 QC 3	12 pcs	1/17/20	0.00 0.00	QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
				QC 3 - 19		DAS 82 9-89
				QC 3 - 43		
				QC 3 - 24		
				QC 3 - 61		
				QC 3 - 81		FEB 25 2020
210 Packaging 3-1 - Stock B4B	12 pcs	1/17/20	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		DAS 74 9-89
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B	ST 445A	FEB 26 2020
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		

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				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220	QC 21 - SA	12 pcs	1/17/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

DAS

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9-55

FEB 26 2020

Part Op **100** - 1-Cut as per Dwg D3319 Dwg Rev: D Prog Rev: D 2-Deburr if necessary

Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

140 - Form using DT8326 & DT8261 as per Dwg D3319

150 - (QC5- Inspect part completeness to step on W/O)

160 - 8259 Hardcoat Rod M139/27

170 - (QC10- Inspect visual per QSI004- ground welds)

180 - (QC5- Inspect part completeness to step on W/O)

190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.

BATCH: 5247847

200 - (QC3- Inspect Part Finish)

210 - (Identify as per dwg & Stock Location: _____) Identify on inside surface using a permanent fine point marker with the following:

220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	39 sf (3.25 ea)	100-Waterjet - Flow - 1	<u>5242863</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	39	166	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189	0.192	
2	Wearplate	0.500inches + 0.006 - 0.001	0.506 0.499	0.499	
3	Wearplate	0.316inches ± 0.010	0.326 0.306	0.314	
4	Wearplate	0.607inches ± 0.010	0.617 0.597	0.607	
5	Wearplate	2.940inches ± 0.030	2.970 2.910	2.950	
6	Wearplate	2.690inches ± 0.030	2.720 2.660	2.704	
7	Wearplate	3.527inches ± 0.010	3.537 3.517	3.527	
8	Wearplate	4.520inches ± 0.030	4.550 4.490	4.52	
9	Wearplate	5.063inches ± 0.010	5.073 5.053	5.059	
10	Wearplate	6.160inches ± 0.030	6.190 6.130	6.158	
11	Wearplate	0.600inches ± 0.030	0.630 0.570	0.610	
12	Wearplate	8.690inches ± 0.010	8.700 8.680	8.694	
13	Wearplate	30.790inches ± 0.010	30.800 30.780	30.790	
14	Wearplate	52.880inches ± 0.030	52.910 52.850	52.880	
15	Wearplate	62.770inches ± 0.010	62.780 62.760	62.770	
16	Wearplate	74.420inches ± 0.010	74.430 74.410	74.420	
17	Wearplate	75.520inches ± 0.030	75.550 75.490	75.520	
18	Wearplate	0.050inches ± 0.010	0.060 0.040	0.049	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Date: _____

NCR No.

Route update only

[illegible]